

# Work Order ID 81028

**\*81028\***

Page 1

March-06-12 4:28:04 PM

Item ID: D3997-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Placard  
 Start Date: 06/03/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 20/03/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3997	A								

100 0.00

**\*100\***

Purchasing

Purchasing

Memo

Issue P/O: 14343  
 Manufacture as per Dwg D3997  
 Possible Supplier: Studio Lettrage  
 Material release note required

0.00

12-03-7

110

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*110\***

Packaging

Packaging

Memo

0.00

12/3/13 (10)

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Quality Control

Memo

0.00

8 12/3/13

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81028

**\*81028\***

Page 2

March-06-12 4:28:04 PM

Item ID: D3997-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Placard  
 Start Date: 06/03/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 20/03/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <b>STH1</b>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

(10x)

SP 12-03-13.

12/3/14

12/3/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-06-12 4:28:08 PM

Page 1

Work Order ID: 81028

\*81028\*

Parent Item: D3997-5

\*D3997-5\*

Parent Item Name: Placard

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A 10.01.12 new issue Prelim EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-5P *D3997-5P* Placard		Purchased	No				Each	90.0000	**	10		P12/3/13 (10)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

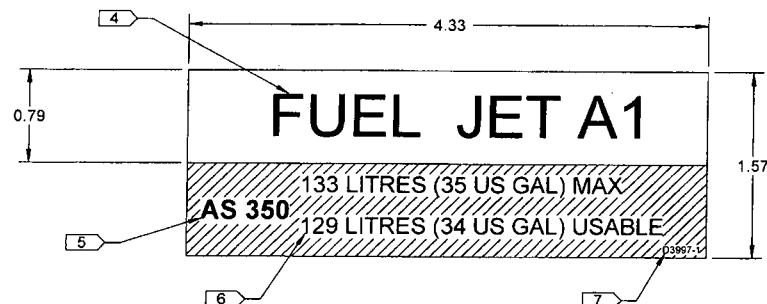
**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-1	JCA-M47-P1
D3997-3	JCA-M47-P2

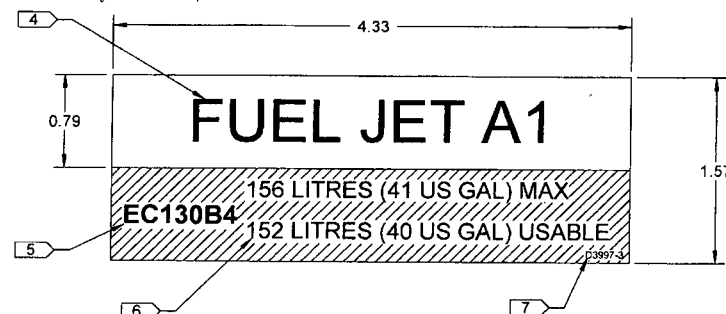
PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-1	FOR AS350 AIRCRAFT - ADJACENT TO FUEL FILLER
D3997-3	FOR EC130 AIRCRAFT - ADJACENT TO FUEL FILLER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 81028 *MLJ*  
*12/03/06*



D3997-1 PLACARD



D3997-3 PLACARD

**RELEASED**  
2010-01-11  
*MD*

**NOTES:**

- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) 36 PT FONT, BLACK TEXT ON WHITE BACKGROUND
- 5) 16 PT BOLD FONT, WHITE TEXT ON BLACK BACKGROUND
- 6) 14 PT FONT, WHITE TEXT ON BLACK BACKGROUND
- 7) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND

A	NEW ISSUE	DESCRIPTION	BY	DATE
REV.				
DESIGN		<b>DART AEROSPACE LTD</b>		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3997		SHEET 1 OF 6
APPROVED		TITLE	SCALE	
DE APPR.		PLACARD	NTS	
DATE	09.10.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

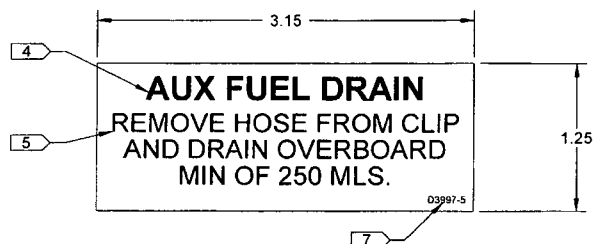
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

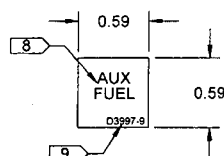


DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-5	JCA-M47-P3
D3997-7	JCA-M47-P4
D3997-9	JCA-M47-P5
D3997-11	JCA-M47-P6

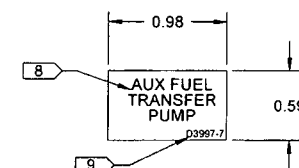
PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-5	ON TANK ADJACENT TO FUEL DRAIN
D3997-7	ADJACENT TO PUMP SWITCH ON INSTRUMENT PANEL
D3997-9	IN AIRCRAFT SWITCH PANEL
D3997-11	ON TANK OUTBOARD SURFACE



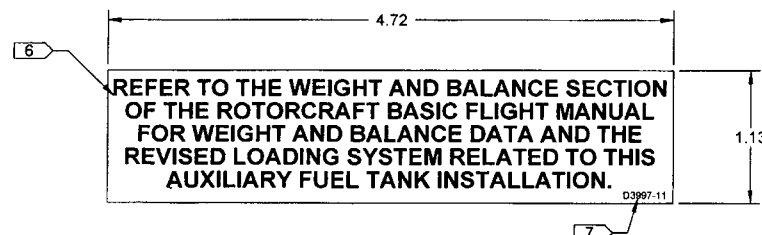
**D3997-5 PLACARD**



**D3997-9 PLACARD**



**D3997-7 PLACARD**



**D3997-11 PLACARD**

**RELEASED**  
2010-01-11  
JMP

**NOTES:**

- 1) MATERIAL: 3M 7 MIL MASKING FILM #9522CP OR AVERY IPM #2031
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) 20 PT FONT, BLACK TEXT ON WHITE BACKGROUND
- 5) 16 PT FONT, BLACK TEXT ON WHITE BACKGROUND
- 6) 14 PT BOLD FONT, BLACK TEXT ON WHITE BACKGROUND
- 7) 6 PT FONT, BLACK TEXT ON WHITE BACKGROUND
- 8) 10 PT FONT, WHITE TEXT ON BLACK BACKGROUND
- 9) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3997</b>	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE <b>PLACARD</b>	SCALE NTS
DE APPR.	<i>[Signature]</i>		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

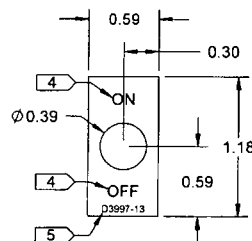
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

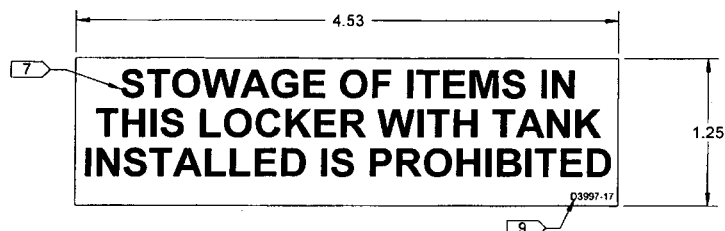
**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-13	JCA-M47-P7
D3997-15	JCA-M47-P8
D3997-17	JCA-M47-P9
D3997-19	JCA-M47-P10

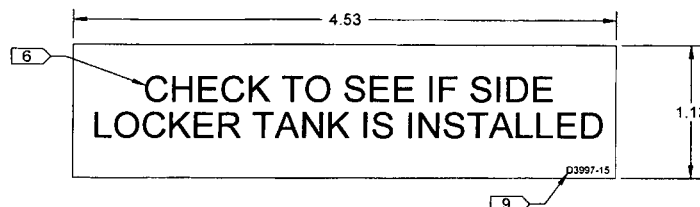
PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-13	AROUND FUEL PUMP ON/OFF SWITCH
D3997-15	ON BAGGAGE LOCKER OUTER SURFACE BELOW RELEASE BUTTON
D3997-17	ON TANK OUTBOARD SURFACE
D3997-19	AT VENT LINE OUTLET ON AIRCRAFT



**D3997-13 PLACARD**



**D3997-17 PLACARD**



**D3997-15 PLACARD**



**D3997-19 PLACARD**

**NOTES:**

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- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) 10 PT FONT, WHITE TEXT ON BLACK BACKGROUND
- 5) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND
- 6) 22 PT FONT, BLACK TEXT ON WHITE BACKGROUND
- 7) 24 PT BOLD FONT, BLACK TEXT ON WHITE BACKGROUND
- 8) 18 PT BOLD FONT, BLACK TEXT ON WHITE BACKGROUND
- 9) 6 PT FONT, BLACK TEXT ON WHITE BACKGROUND

**RELEASED**  
R 2010-01-11

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3997
MFG. APPR.	<i>[Signature]</i>	REV. A
APPROVED	<i>[Signature]</i>	SHEET 3 OF 6
DE APPR.	<i>[Signature]</i>	TITLE PLACARD
DATE	09.10.05	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

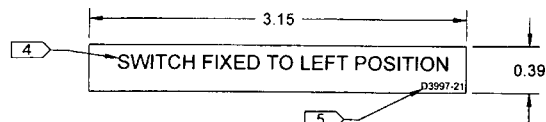
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

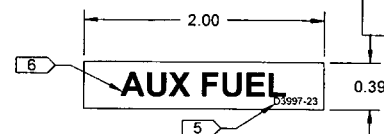
**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-21	JCA-M47-P13
D3997-23	JCA-M47-P14
D3997-25	JCA-M47-P15
D3997-27	JCA-M47-P16

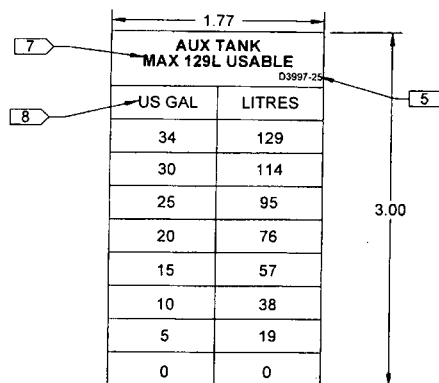
PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-21	ON AUX FUEL GAUGE SWITCH PLATE
D3997-23	ON AUX FUEL GAUGE
D3997-25	NEXT TO AUX FUEL GAUGE (AS 350 ONLY)
D3997-27	NEXT TO AUX FUEL GAUGE (EC 130 ONLY)



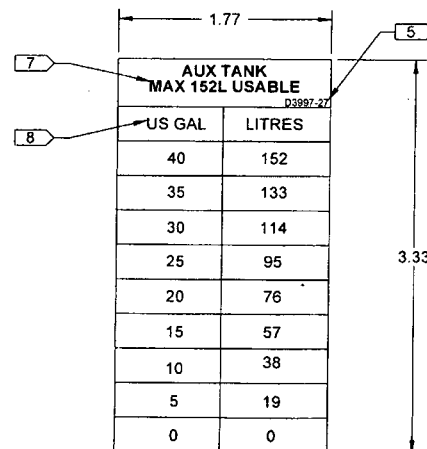
**D3997-21 PLACARD**



**D3997-23 PLACARD**



**D3997-25 PLACARD**



**D3997-27 PLACARD**

81028

**RELEASED**  
2010-01-11

- NOTES:**
- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) 12 PT FONT, WHITE TEXT ON BLACK BACKGROUND
  - 5) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND
  - 6) 20 PT BOLD FONT, WHITE TEXT ON BLACK BACKGROUND
  - 7) 10 PT BOLD FONT, WHITE TEXT ON BLACK BACKGROUND
  - 8) 10 PT FONT, WHITE TEXT ON BLACK BACKGROUND

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3997</b> REV. A
MFG. APPR.		SHEET 4 OF 6
APPROVED		TITLE <b>PLACARD</b> SCALE NTS
DE APPR.		
DATE	09.10.05	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

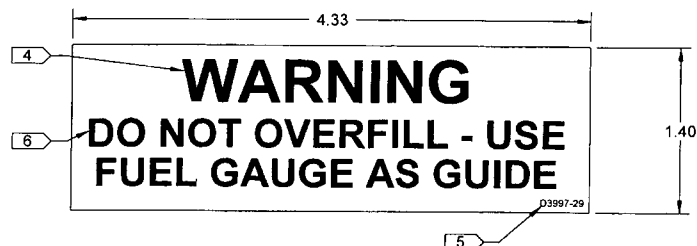
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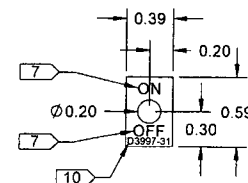
**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-29	JCA-M47-P17
D3997-31	JCA-M47-P18
D3997-33	JCA-M47-P19
D3997-35	JCA-M47-P20

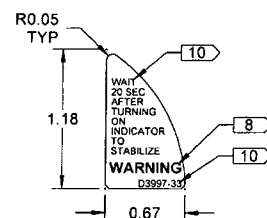
PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-29	ADJACENT TO FUEL FILLER
D3997-31	AROUND AUX FUEL GAUGE ON/OFF SWITCH ON INSTRUMENT PANEL
D3997-33	ON AUX FUEL GAUGE COVER
D3997-35	ADJACENT TO AUX FUEL GAUGE ON/OFF SWITCH ON INSTRUMENT PANEL



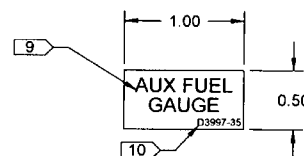
**D3997-29 PLACARD**



**D3997-31 PLACARD**



**D3997-33 PLACARD**



**D3997-35 PLACARD**

**NOTES:**

- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) 36 PT BOLD FONT, RED TEXT ON WHITE BACKGROUND
- 5) 6 PT FONT, BLACK TEXT ON WHITE BACKGROUND
- 6) 24 PT BOLD FONT, BLACK TEXT ON WHITE BACKGROUND
- 7) 10 PT FONT, WHITE TEXT ON BLACK BACKGROUND
- 8) 9 PT BOLD FONT, WHITE TEXT ON BLACK BACKGROUND
- 9) 12 PT FONT, WHITE TEXT ON BLACK BACKGROUND
- 10) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3997
MFG. APPR.		REV. A
APPROVED		TITLE PLACARD
DE APPR.		SCALE
DATE	09.10.05	NTS

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RELEASED  
2010-01-11

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

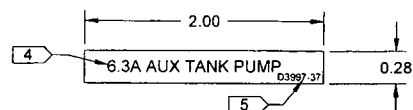
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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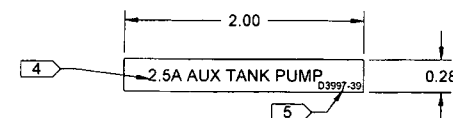


DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-37	JCA-M47-P21
D3997-39	JCA-M47-P22
D3997-41	JCA-M47-P23
D3997-43	JCA-M47-P24

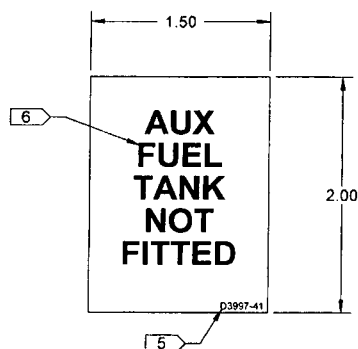
PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-37	ADJACENT TO CB INSTALL
D3997-39	ADJACENT TO CB INSTALL
D3997-41	ON TANK ADJACENT TO FUEL FILLER
D3997-43	ON TANK EARTH POINT



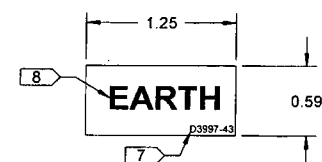
**D3997-37 PLACARD**



**D3997-39 PLACARD**



**D3997-41 PLACARD**



**D3997-43 PLACARD**

**NOTES:**

- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) 10 PT FONT, WHITE TEXT ON BLACK BACKGROUND
- 5) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND
- 6) 20 PT BOLD FONT, WHITE TEXT ON BLACK BACKGROUND
- 7) 6 PT FONT, BLACK TEXT ON WHITE BACKGROUND
- 8) 20 PT BOLD FONT, BLACK TEXT ON WHITE BACKGROUND

**RELEASED**  
2010-01-11

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3997</b>
MFG. APPR.		REV. A
APPROVED		TITLE <b>PLACARD</b>
DE APPR.		SCALE <b>NTS</b>
DATE	<b>09.10.05</b>	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Studio de Lettrage

210 Main Street W  
Hawkesbury, Ontario K6A 2H6

## INVOICE

Invoice No.: 17494  
Date: 03/12/2012  
Ship Date: 03/09/2012  
Page: 1  
Re: Order No. WO6782

**Sold to:**

Dart Aerospace Ltd  
1270 ~~A~~ <sup>W</sup>arden  
Hawkesbury, Ontario K6A 1K7

**Ship to:**

Dart Aerospace Ltd  
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
	<i>S2103113</i>	10	D3997-5P	H		
		10	D3997-7P	H		
		10	D3997-15P	H		
		10	D3997-19P	H		
		10	D3997-21P	H		
		10	D3997-25P	H		
		10	D3997-31P	H		
		10	D3997-35P	H		
		10	D3559-41P	H		
		9	setup	H	50.00	450.00
		1	printing batch	H	100.00	100.00
			H - HST 13%			
			HST			71.50
			PST Exempt: #6122-5207			
Studio de Lettrage HST: #825007651RT0001						
Shipped By: Tracking Number:						
Comment: <i>PO 016363</i>						
Sold By:						
Total Amount						621.50





## Product & Instruction Bulletin 8522

Release 1, Effective September 2008  
See Bulletin Change Summary and end of Bulletin  
This Bulletin now includes instruction Bulletin 4121

# Scotchcal™ Changeable Opaque Imaging Media 8522

### For Thermal Inkjet Printing

## Product Description

This durable, 7 mil, opaque, changeable film is optimized for use with selected thermal inkjet printers and inks. Ink dries quickly on the film. When overlaminated, it is warranted for medium term, outdoor weatherable graphics, and long term indoor graphics.

## Recommended Types of Graphics and End Uses

When constructed and used as described in this Bulletin, these types of graphics and end uses may be warranted by the 3M™ MCS™ Warranty. Please read the entire Bulletin for details.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
  - Graphics for vans, personal vehicles, trucks and buses
  - Novelty posters
  - Retail and point-of-purchase displays
  - Information graphics such as maps and directories
  - Entertainment promotions in museums, zoos, parks, theatres, sports venues
  - Education and presentation graphics
  - Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications

## Limitations of End Uses

3M specifically does not recommend or warrant the following uses, but please contact us to discuss your needs or recommend other products.

### Unsuitable End Uses for This Product

- Not for electronically cut individual letters and numbers
- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wallboard
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.
- Graphics made for automotive Original Equipment Manufacturers (OEM); contact 3M Automotive Division at 1-800-328-1684 for alternatives.

## About Water-Based Inkjet Technology

Standard inkjet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this Bulletin. Staying in the middle of these ranges always provides optimum performance.

## Compatible Products

### 3M Graphic Materials

For complete details about graphic construction options, recommended uses and durability, refer to the Product Bulletin for the base film or substrate (media) you are using. See **3M Related Literature** at the end of this Bulletin.

This Bulletin provides details about the base film and construction options and warranty. Additional specific information about compatible products can be found in the Product and Instruction Bulletins listed in **3M Related Literature** at the end of this bulletin.

### 3M Graphic Materials

For complete details about graphic construction options, recommended uses and durability, refer to the Product Bulletin for the base film or substrate (media) you are using. See **3M Related Literature** at the end of this Bulletin.

#### Film

- 3M™ Scotchcal™ Opaque Imaging Media 8522

#### Overlamine

- 3M™ Scotchcal™ Luster Overlamine 8519
- 3M™ Scotchcal™ Matte Overlamine 8520

#### Printers and Inks

HP Designjet Printers	HP Inks
<ul style="list-style-type: none"><li>• 2500CP and 2000CP</li><li>• 2800CP and 3800CP</li><li>• 3500CP and 3000CP</li><li>• HP Designjet 5000 and 5500</li></ul>	<ul style="list-style-type: none"><li>• Designjet CP Ink System UV (pigment-based)</li><li>• Designjet CP Inkjet System (imaging ink)</li></ul>
<ul style="list-style-type: none"><li>• Z6100</li></ul>	<ul style="list-style-type: none"><li>• HP 91 Vivera Ink System</li></ul>

Epson Printers	Epson Inks
<ul style="list-style-type: none"><li>• Stylus Pro 9500</li><li>• Stylus Pro 10000 printer</li><li>• Stylus Pro 10600 printer</li></ul>	<ul style="list-style-type: none"><li>• Archival Inks</li></ul>

## Characteristics

These are typical values for unprocessed product; processing may change the values. Contact your 3M representative for a custom specification.

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness	<b>Media with adhesive:</b> 7.5 to 8 mil (nominal)
Warranted application substrates	See next page.
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Removable	For up to one year; see Warranty Information

Characteristic	Description
Warranted application substrates	<p>Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.</p> <ul style="list-style-type: none"> <li>• Alodine (anodized aluminum)</li> <li>• Automotive panels (automotive painted steel)</li> <li>• Fruehauf (painted aluminum)</li> <li>• FRP (fiberglass reinforced plywood)</li> <li>• Glass</li> <li>• Imron® (polyurethane-painted metal panel)</li> <li>• Acrylic</li> <li>• Sintra™ board</li> </ul> <p>Note: Use on any other substrate is strictly on a graphics manufacturer and customer test and approve basis. Test for both adhesion and removal characteristics. The plasticizer in some banner materials may migrate. This may cause the edge of the graphic to peel or lift off of the banner. For optimum performance, follow the guidelines in the section, Creating A Laminated Overlap, on page 4.</p>

## Warranty Information

The warranty given in the Product Bulletin that is current at the time you purchased the film is the one that 3M will honor. **The warranties in the following table(s), given in years, are for finished graphics exposed in a vertical exposure in the United States except the Desert Southwest.** See the warranty sections following this table for additional information.

### 3M™ MCS™ Warranty Durability for Finished Graphics

Construction (film and overlamine on warranted substrate)	HP Printers & Inks		Epson Printers & Inks		Removal
	Outdoor	Indoor	Outdoor	Indoor	
8522/8519	3 years	5 years	2 years	5 years	1 year without chemical strippers or tools
8522/8520					

## Warranty and Limited Remedy

The following is made in lieu of all other express or implied warranties, including any implied warranty of **merchantability** or fitness for a particular purpose or implied warranty arising out of a course of dealing, custom or usage of trade: all 3M products are warranted to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in this Product Bulletin. 3M will replace or refund the price of any 3M materials that do not meet this warranty within the specified time periods. These remedies are exclusive. **In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor or non-3M materials charges.**

See the Graphics Market Center Warranty Brochure, which gives the terms, additional limitations of the warranty, if any, and limitations of liability.